

Work Order ID 135475

Wednesday, August 12, 2015 4:30:15 PM

135475

Page 1

Item ID: D3270-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fuel Scupper Assembly
 Start Date: 8/12/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/12/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: AUG 14 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3270	Rev B								
100		Small Fab	0.00						
100									
Small Fab		Memo	0.00						
Small Fab		Cut D3270-3 as per Dwg D3270							

110		Weld per dwg A/R Aluminum rod Batch: <u>M129399</u>	0.00						
110									
Large Fab		Memo	0.01						
Large Fab		Weld D3270-3 to D3270-1 as per Dwg D3270 using welding Jig D3270-041T1 and QSI 004.							

120		QC9- Inspect visual per QSI004- Fusion Welds	0.00						
120									
QC		Memo	0.00						
Quality Control									

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
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Page 2

Item ID: D3270-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Fuel Scupper Assembly

Stop

NS2

Start Date: 8/12/15

Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/12/15

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

(2) 15-08-27

DAS
9
9-89

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

2 φ 15-9-2

DAS
34
9-89

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

M 13545

START Time: 8:05

OVEN TEMPERATURE: 320°

FINISH TIME: 8:35

2 φ 15-9-3

DAS
34
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							DAS
160						(2)			38
QC	Memo	0.00							9-89
Quality Control									
165	Identify as per dwg & Stock Location: <u>st 029</u>	0.00							
165						2			27
Packaging	Memo	0.00							9-88
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

SEP 03 2015

SEP 03 2015

SEP 09 2015

20150909

SH

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 135475

135475

Parent Item: D3270-041

D3270-041

Parent Item Name: Fuel Scupper Assembly

Start Date: 8/12/15

Required Date: 8/12/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 05-11-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3270-1		Manufactured	No			100	Each	43.0000	1	2			

D3270-1

Mounting Base

FF Aug-19-2015

Location

Loc Qty

Loc Code

WA002

43

130540

43

M6061T6T0.375W.035

Purchased

No

100

f

98.1500

0.6666

1.403368

M6061T6T0.375W.035

6061-T6 RD Tube .375 x.035W

FF AUG 19 2015

Location

Loc Qty

Loc Code

MAT013

98.15

124491

64.5

m130071

33.65

1.4033

DQA: _____ Date: _____



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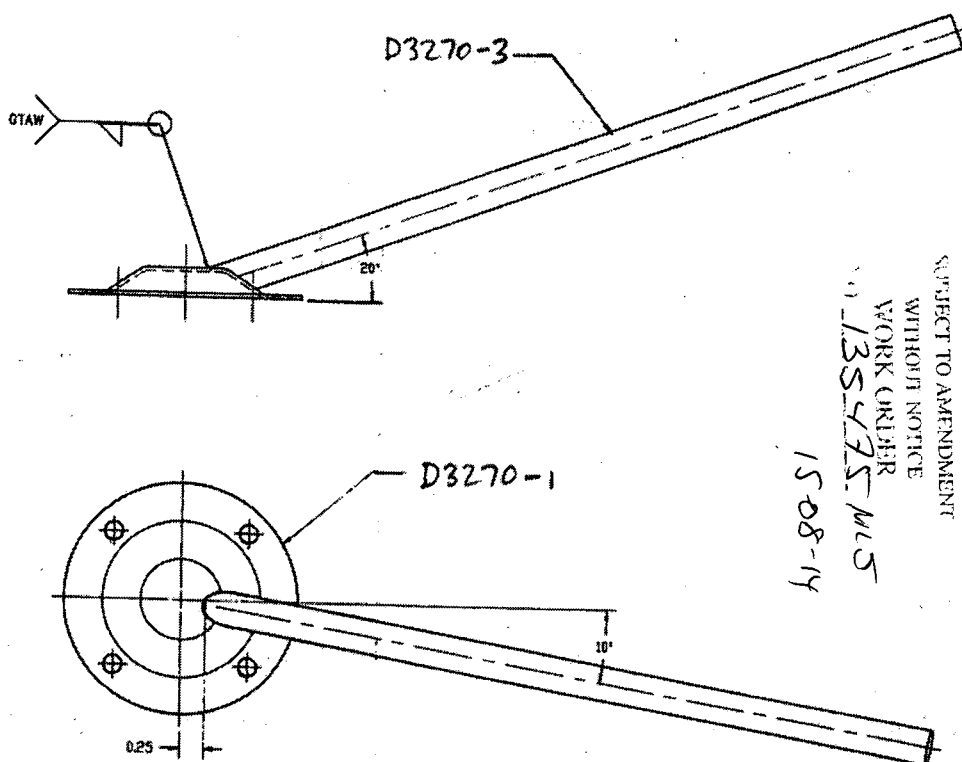
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED #	DRAWING NO. D3270	REV. B SHEET 1 OF 2
DATE 05.07.14		TITLE FUEL SCUPPER DRAIN ASSEMBLY	SCALE NTS
A	04.02.20	NEW ISSUE	
B	# 05.07.14	ADD D3270-1 FLAT PATTERN	

RELEASED
04.02.23



D3270-041 FUEL SCUPPER ASSEMBLY

- NOTES:
- 1) WELD PER DART QSI 004 USING 5356 FILLER ROD.
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER QSI 005 4.3
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) CONTOUR MAY BE ALTERED TO DOMED SHAPE AT FABRICATOR'S DISCRETION

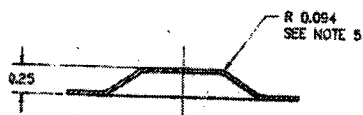
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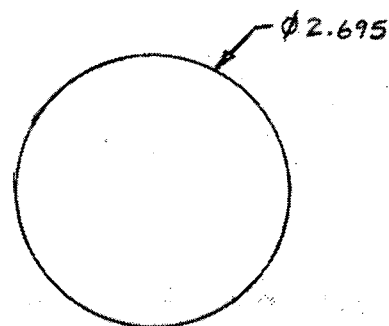
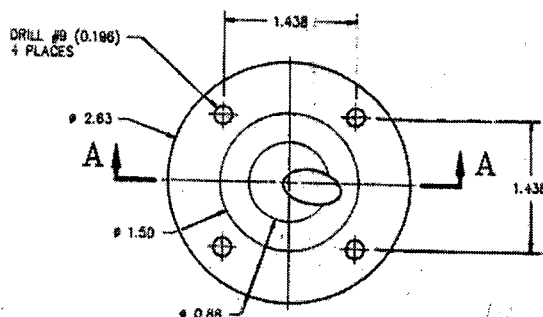


DESIGN	<i>HA</i>	DRAWN BY	<i>HA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>CP</i>	APPROVED	<i>HA</i>	DRAWING NO.	REV. B
DATE				D3270	SHEET 2 OF 2
05.07.14				TITLE	SCALE
				FUEL SCUPPER ASSEMBLY	MTS
A	04.02.20	NEW ISSUE			
B	17 05.07.14	ADD D3270-1 FLAT PATTERN			

RELEASED
04.02.23



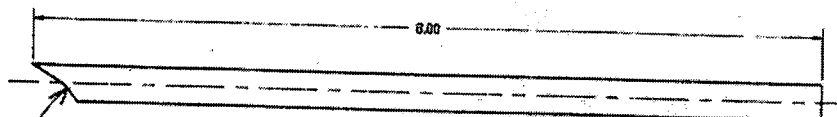
SECTION A-A



D3270-1 FLAT PATTERN

D3270-1 MOUNTING BASE

MATERIAL: 6061-T6 ALUMINUM SHEET 0.040" THICK PER QQ-A-250/11 (M6061T6S.040)



CONTOUR TO FIT
D3270-1

D3270-3 FUEL OUTLET TUBE

MATERIAL: 6061-T6 ALUMINUM TUBING 0.375" OD X 0.035" WALL (SEAMLESS)
PER MW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
(M6061 T6 T0.375W.035)

